



Ship Via:

**DAS
40
9-89**

				QC 5 - 30	
130	Packaging 3-1 - Stock - B4B	1 pcs	4/1/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
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					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	1 pcs	4/1/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op 90 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-
 Descriptions: 1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack
 case as per DWG.

110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and
 pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1200-E	Case	1 Ea (1 ea)	90-Small Fab - 1	5156582
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	5145165
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5021040
105 60F RBW109-3101-86-101-1	Ring, 1-3/4 x 1-3/4 x 3-7/8	4 pcs (4 ea)	110-Small Fab - 2 - B4B	5165207
RBW109-3101-86-101-5	Bottom Foam used in case APP-1200-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5156584
RBW109-3101-86-101-7	Lid Foam used in case APP1200-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5156583

9092

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	APP-1200-E	1	14	0
110-Small Fab - 2 - B4B	97524A032	4	221	0
	RB41011	1	380	0
	RBW109-3101-86-101-1	4	0	0
	RBW109-3101-86-101-5	1	1	0
	RBW109-3101-86-101-7	1	1	0
Part Specifications				
Specifications could not be found.				

Plex 3/14/19 8:23 AM Dart.Dart.Int4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3101-86-101
Job Sheet 189570



Part No: RBW109-3101-86-101

Job Qty: 1 pcs

Part Name: Tool Assembly, Floating Ring Centering



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 4624

Note: DWG RBW109-3101-86-101 Rev.A IPP Rev. A 19.01.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	4/10/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	4/10/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/10/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	4/10/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 1	
APP-1200-E	Case	1 Ea (1 ea)	110-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 1	
RBW109-3101-86-101-1	Ring, 1-3/4 x 1-3/4 x 3-7/8	4 pcs (4 ea)	110-Small Fab - 1	
RBW109-3101-86-101-5	BOT TOP FOAM			
RBW109-3101-86-101-7	TOP FOAM			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	4	739	0
	APP-1200-E	1	19	0
	RB41011	1	482	0
	RBW109-3101-86-101-1	4	0	0

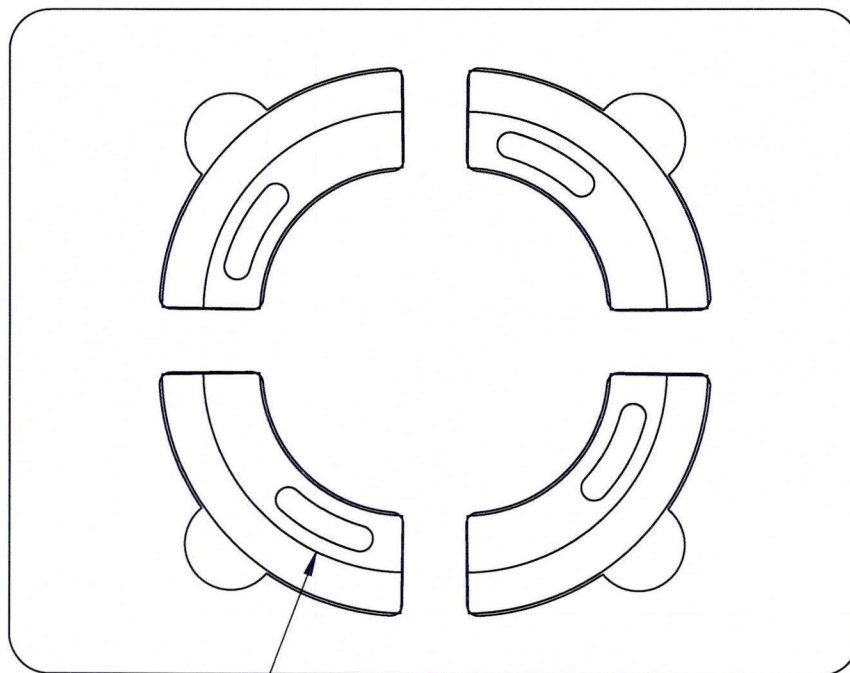
Part Specifications

Specifications could not be found.

Plex 1/28/19 1:50 PM Dart.lajeunesse.marie

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TOOL NAME WAS DROOP RING CENTERING IS TOOL ASSY. FLOATING RING CENTERING.	11/8/2013	RJC	RW



4X (-1)

(-5)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189570 MCL
190128

 RED BARN MACHINE	
TITLE TOOL ASSY. FLOATING RING CENTERING	
DWG NO. RBW109-3101-86-101	REV A
MATERIAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
DRAWN BY: CLOUGH	
APPROVED D Weil	
HEAT TREAT FINISH	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL A109E, A119	
SCALE 1:2	DATE 12/18/2012
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	4	RING	6061	1-3/4 x 1-3/4 x 3-7/8	2
		B/O	-3	1	CASE	PLASTIC	PELICAN #APP-1200-E	N/S
		B/O	-5	1	BOTTOM FOAM	Y-20, BLACK	2-15/16 X 7-1/4 X 9-3/16 I.R. SPECIALTIES	3
		B/O	-7	1	LID FOAM	Y-20, BLACK	1-3/16 X 7-1/8 X 9-3/8 I.R. SPECIALTIES	4
		B/O	-9	1	RED BARN PLACARD	PLASTIC	RB41009	N/S

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					